

Date: Tuesday, 12/5/2006 8:01:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, LH, 206
 Job Number : 29748
 Estimate Number : 10818
 P.O. Number : N/A Part Number : D26651
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2665 REV. C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 28601 Material : N/A
 Due Date : 1/5/2007 Qty: 12 Um: Each
 Written By : JA 06 12 05
 Checked & Approved By : JA 06 12 05
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88"
 Grain Along Long 7.88 Length Batch no B25346 ml 06/12/14

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 3-Fixturing Inspection last completed on 06/12/14 by ml
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 7- Deburr ml/SD/06.12.16 (12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet ml/SD/06.12.16 (12)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE


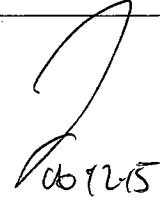

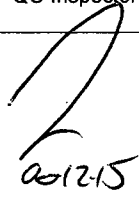


Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml/SD/06.12.16 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.12.14	Z	Tooling rad for flange pockets should be R0.188 per marked-up dwg. Saddle-to-cross tube holes should be R0.316. REF: Attached DS email.	ml	06/12/15	12	CP 66.12.14 per 851042	06/12-19	

Part No: D2665-1 PAR #: N/A Fault Category: Red Machine ⁷⁴⁵ NCR: Yes No DQA: 1 Date: 06/12/22
QA: N/C Closed: 1 Date: 06.12.22

NCR: <u>29748</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/15	2	^{issue scrap} the thickness of the skid bolt face are too thin of .015"		Give to eng Scrap & destroy replace	ml 06/12/15			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:01:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 29748

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 06/12/19

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 a.m./BR

06/12/19 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-L/m-m

06/12/20 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m 06 12 20

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57482

06/12/21

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/22

(12)

Job Completion



U060222

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 29748
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.118	0.117	0.118	0.119		
B	0.100	0.140		0.130	0.129	0.130	0.130		
C	1.125	1.145		1.136	1.135	1.134	1.136		
D	0.615	0.685		0.658	0.655	0.660	0.658		
E	0.240	0.260		0.254	0.253	0.251	0.251		
F	1.313	1.343		1.325	1.323	1.323	1.323		
G	0.210	0.230		0.232	0.218	0.219	0.222		
H	0.100	0.180		0.140	0.145	0.145	0.142		
I	2.470	2.510		2.498	2.498	2.498	2.499		
J	1.565	1.585		1.571	1.571	1.571	1.572		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.114	0.111	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.511	0.511	0.512	0.512		
O	5.990	6.010		6.001	6.002	6.002	6.001		
P	1.245	1.255		1.249	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.321		0.320	0.320	0.320	0.320		
T	2.495	2.505		2.500	2.500	2.499	2.499		
U	1.357	1.367		1.362	1.361	1.361	1.361		
V	0.787	0.807		0.794	0.793	0.792	0.793		
W	0.540	0.560		0.544	0.551	0.550	0.550		
X	1.674	1.684		1.680	1.680	1.678	1.678		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.925	0.926	0.926	0.925		
AA	0.490	0.510		0.500	0.500	0.501	0.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>amk / J.L.</u>	Audited by: <u>J.F.</u>
Date: <u>06/12/15</u>	Date: <u>06/12/18</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 29748
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.120	.120		
B	0.100	0.140		.125	.125	.126	.125		
C	1.125	1.145		1.133	1.135	1.135	1.135		
D	0.615	0.685		.650	.650	.650	.650		
E	0.240	0.260		.250	.250	.250	.250		
F	1.313	1.343		1.325	1.324	1.324	1.325		
G	0.210	0.230		.221	.221	.221	.221		
H	0.100	0.180		.145	.145	.145	.145		
I	2.470	2.510		2.500	2.500	2.500	2.500		
J	1.565	1.585		1.572	1.573	1.572	1.573		
K	0.235	0.240		.237	.238	.237	.238		
L	0.100	0.120		.111	.110	.111	.112		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.000	6.003	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.319	.319	.314	.314		
S	0.315	0.320		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.794	.796	.795		
W	0.540	0.560		.550	.550	.550	.551		
X	1.674	1.684		1.679	1.679	1.679	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.924	.924	.924	.922		
AA	0.490	0.510		.500	.500	.500	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD / J.L.	Audited by: J.F.
Date: 06.12.16 / 06/12/18	Date: 06/12/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	




DART AEROSPACE LTD	Work Order: 29748
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. C	Page 1 of 1

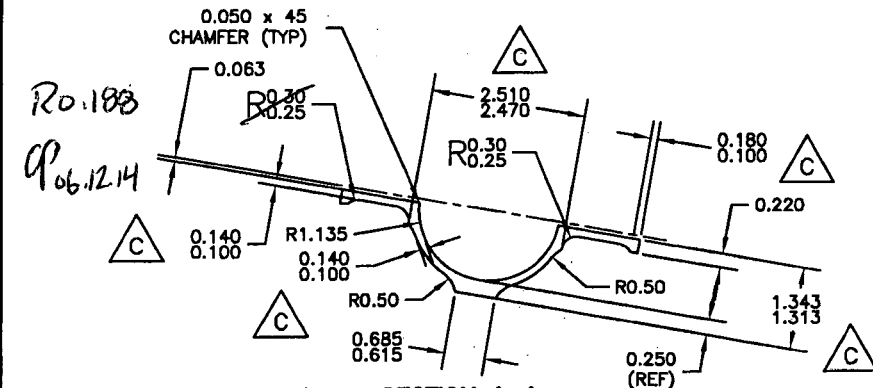
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.120	.120		
B	0.100	0.140		.125	.125	.125	.125		
C	1.125	1.145		1.135	1.135	1.133	1.135		
D	0.615	0.685		.650	.650	.650	.650		
E	0.240	0.260		.250	.250	.2500	.2500		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.221	.221	.221	.221		
H	0.100	0.180		.145	.145	.145	.145		
I	2.470	2.510		2.500	2.500	2.500	2.500		
J	1.565	1.585		1.572	1.572	1.573	1.572		
K	0.235	0.240		.237	.238	.237	.238		
L	0.100	0.120		.111	.112	.111	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.002	6.003	6.002	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.794	.794	.795		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.678	1.678	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.924	.924	.923	.927		
AA	0.490	0.510		.500	.500	.500	.500		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

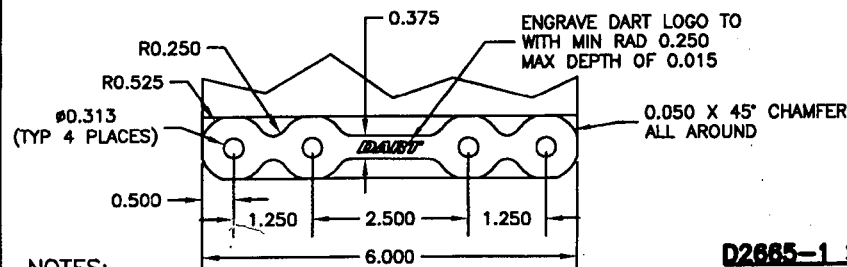
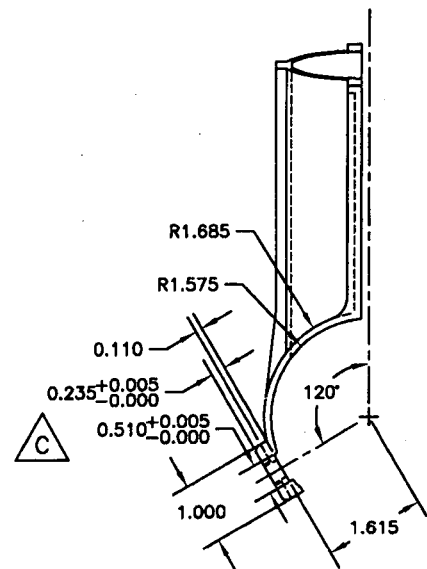
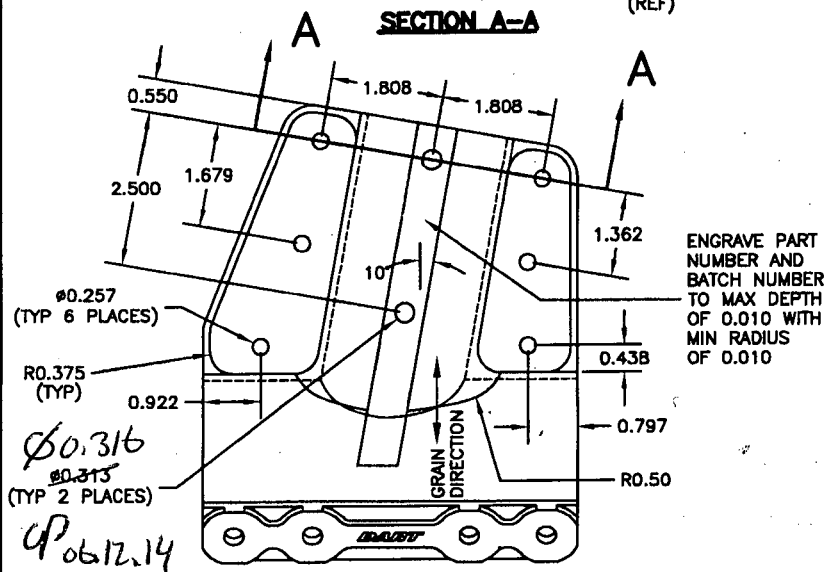
Measured by: SD	Audited by: J.F.
Date: 06.12.16	Date: 06/12/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DESIGN 		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2665 REV. C SHEET 1 OF 1	
DATE 06.05.29		TITLE SADDLE FWD OUTSIDE HIGH		SCALE 1:3	
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095			



RELEASED
06.06.28
UNDER REVIEW



D2685-1 SADDLE END OUTSIDE HIGH

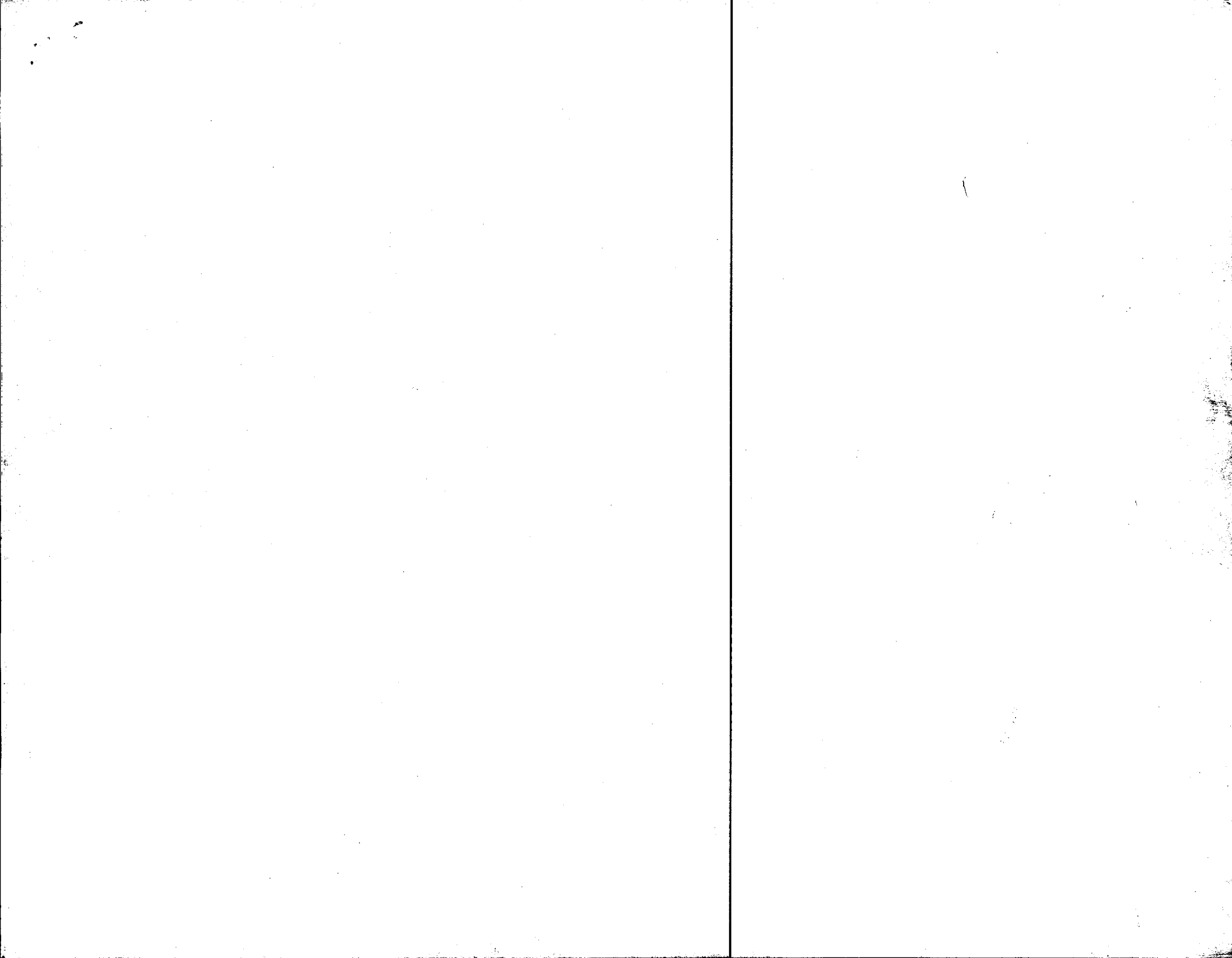
- NOTES:**
- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29748

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

14/12/2006